

Work Order ID 83539

83539

Page 1

April 19-12 11:23:43 AM

Item ID: D4434-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd inboard Bracket Assembly

Start Date: 19/04/2012 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/19 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4434

B

(6)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

6061.040

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B12-5-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4434-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Stop

NS2

Start Date: 19/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizlar

6

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

6

S
12/05/29

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

6

whl 12.05.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop ***NS2***

Item Name: Fwd inboard Bracket Assembly

Start Date: 19/04/2012 Start Qty: 5.00

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Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

(6) 2/16/12 5-29

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

6 8 12/06/12

180

0.00

180

Small Fab

Memo

0.00

Small Fab

1-C'sink as per dwg.

2-Assemble as per dwg, do not install grommets and rubber seal.

6 0 FF 12-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D4434-043

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Setup Start ***NS1***

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Stop ***NS2***

Start Date: 19/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

185

QC5- Inspect part completeness to step on W/O

0.00

185

QC

Memo

0.00

Quality Control

6

12/06/22

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

*** MASK NUT PLATE HOLES PER DWG ***

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50 F
320 F
9:20

6X

12/07/03

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

6

X

12/07/03

W121279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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83539

Page 5

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/04/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 03/05/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0,00

202

Small Fab

Memo

0.00

Small Fab

Install rubber seals and grommets.

3M 1300 batch: 122346

205

QC5- Inspect part completeness to step on W/O

0.00

205

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: *63A*

0.00

210

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 83539***83539***

Page 6

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Revision ID:

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Stop ***NS2***

Start Date: 19/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 12/07/12

ME
12-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-19-12 11:23:47 AM

Page 1

Work Order ID: 83539

83539

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP revA 11.10.06 new issue EC verified by:DD
 11.12.22 per PA5 EC verified by:JLM
 per REV.A DD verified by:EC
 DD verified by:EC
 IPP RevB
 IPP RevC 12.01.24
 IPP RevD 12.03.05 per REV.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	348.0278	2.5	13.15789	15.		

M6061T6S 040

6061-T6.040 Sheet

**

B12-5-19

Location	Loc Qty	Loc Code
MAT021	348.0278	
121030	77.5278	
121099	270.5	

121030

6

D4434-9

Manufactured No

180 Each

7.0000

1

5

D4434-9

Bracket

**

6

FF12-06-21

Location	Loc Qty	Loc Code
GA	83906	
80675	1	
82298	6	

6

D4435-041

Manufactured No

180 Each

12.0000

1

5

D4435-041

Bracket Assembly

**

6

FF12-07-12

Location	Loc Qty	Loc Code
ST139	11	
82299	11	
ST441	1	
80678	1	

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April-19-12 11:23:47 AM

Page 2

Work Order ID: 83539

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

83539

D4434-043

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

D4441-1 Manufactured No

202 f

63.7986 0.142 0.71

D4441-1

Rubber Seal

**

⑥ FF 12-07-11

Location

Loc Qty

Loc Code

prelim	6.739
74760	6.739
ST413	57.0596
79385	49.8636
80763	7.196

0.71 860

Cut qty 1 to 1.7"

D4441-1 Manufactured No

f

63.7986 1.04

D4441-1

Rubber Seal

**

⑥ FF 12-07-11

Location

Loc Qty

Loc Code

prelim	6.739
74760	6.739
ST413	57.0596
79385	49.8636
80763	7.196

1.04 1.250

Cut qty 1 to 2.5"

D4441-1 Manufactured No

f

63.7986 9.375

D4441-1

Rubber Seal

**

⑥ FF 12-07-11

Location

Loc Qty

Loc Code

prelim	6.739
74760	6.739
ST413	57.0596
79385	49.8636
80763	7.196

9.375 11.25

Cut qty 1 to 22.5"

April-19-12 11:23:47 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April-19-12 11:23:47 AM

Page 3

Work Order ID: 83539

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

83539

D4434-043

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

D4440-1 Manufactured No

202 Each

57.0000

1 5

D4440-1

Grommet

**

⑥ FF 12-07-12

Location

Loc Qty

Loc Code

GA

54

80645

54

prelim

2

74759

2

ST139F

1

79372

1

AN525-832R6

Purchased No

180 Each

259.0000

3 15

AN525-832R6

Screw

**

⑥ FF 12-07-12

Location

Loc Qty

Loc Code

ST345

259

120308

1

120560

258

MS20426AD3-2

3

Purchased No

180 Each

18,319.00

12 60

MS20426AD3-2

Rivet

**

⑥ FF 12-06-21

Location

Loc Qty

Loc Code

Mezz

121011

18319

1173

8919

13276

9400

72

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April-19-12 11:23:47 AM

Page 4

Work Order ID: 83539

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

83539

D4434-043

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

MS20426AD3-3

Purchased

No

180

Each

3,737.000

2

10

MS20426AD3-3

Rivet

**

⑥ FF 12-06-21

Location

Loc Qty

Loc Code

ST316

3737

119109

655

121011

2647

19099

435

12

MS20470AD4-3

Purchased

No

180

Each

5,495.000

5

25

MS20470AD4-3

Rivet - Universal Head

**

⑥ FF 12-06-21

Location

Loc Qty

Loc Code

Mezz

5495

1642

861

2193

4634

30

MS21075L08

Purchased

No

180

Each

138.0000

7

35

MS21075L08

ANCHOR NUT

**

6 FF 12-06-21

Location

Loc Qty

Loc Code

ST303

58

111578

2

120560

56

ST304

50

121255

50

ST308

30

120930

30

30

12

121708

April-19-12 11:23:47 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

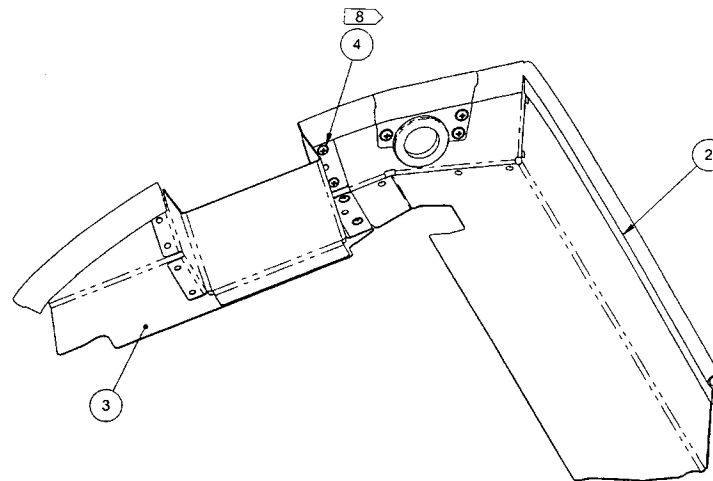
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83539 MLT
12/04/19

RELEASED
R 2012-05-02
JWP

D4434-041 FWD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

B	RE-DESIGN D4434-9F-9F (ZN 85-14, A5-15)	RF	12.02.22
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 1 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.02.22	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

5

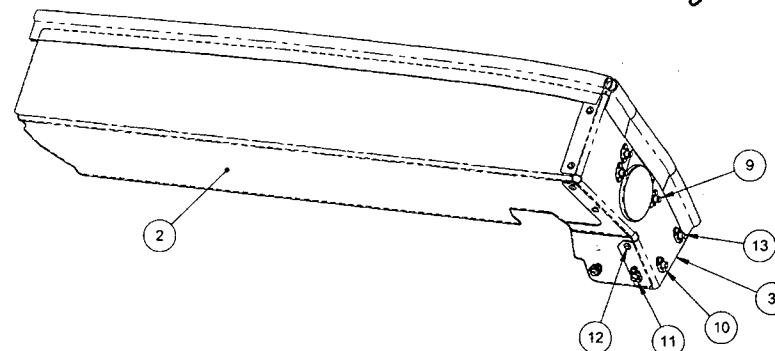
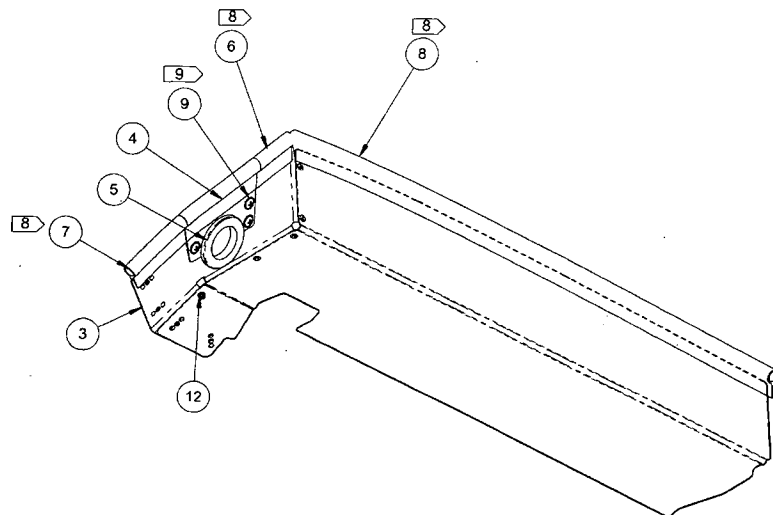
4

3

2

1

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE



83539

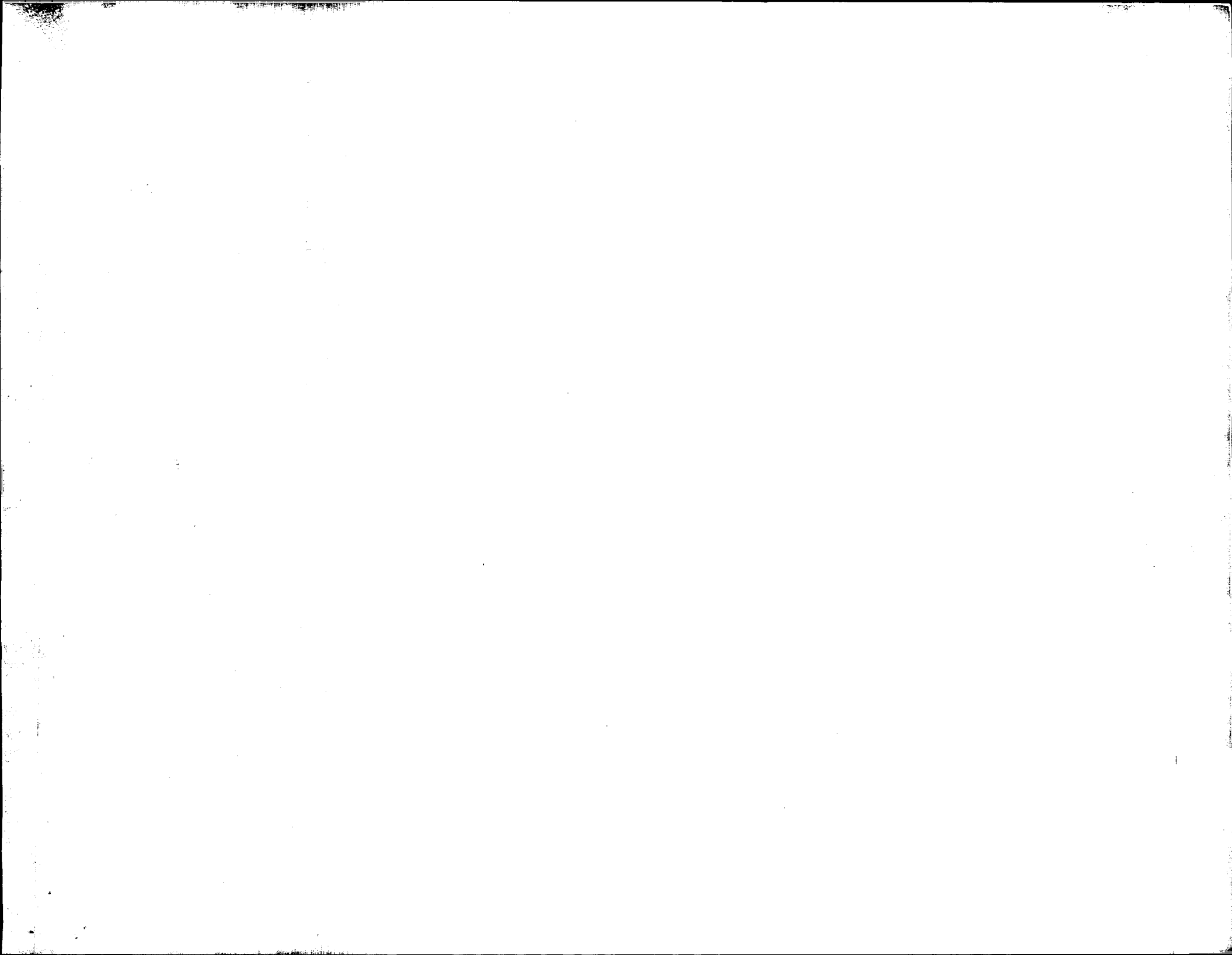
RELEASED
2012-03-02

D4434-043 FWD INBOARD BRACKET ASSEMBLY

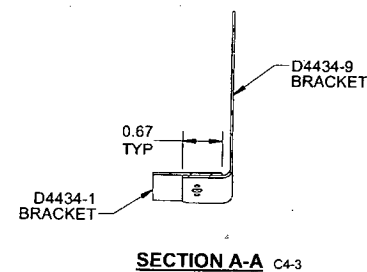
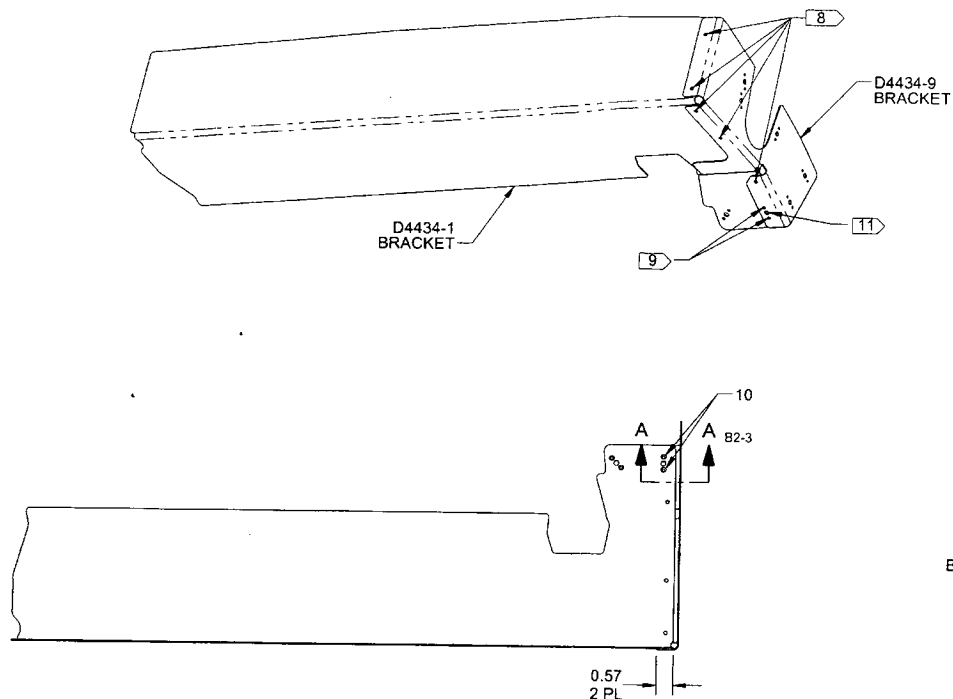
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	CE	D4434	SHEET 2 OF 15
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	COVER ASSEMBLY	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



83539



NOTES:

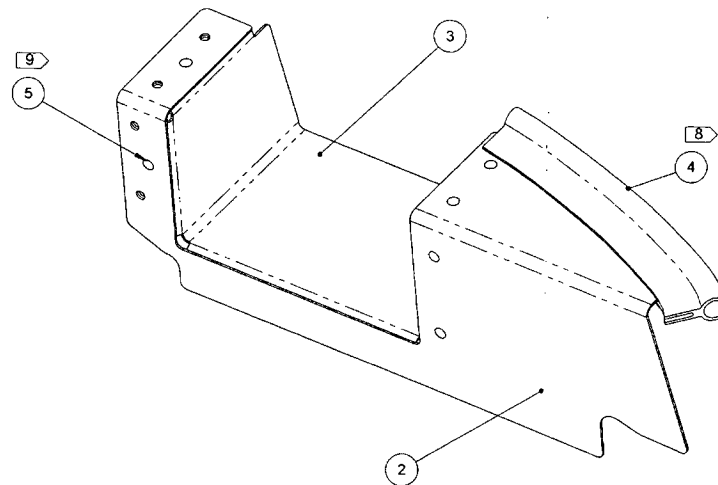
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER $\varnothing 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK $\varnothing 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 11) TRANSFER $\varnothing 0.177$ HOLE THRU FROM D4434-9 TO D4434-1

D4434-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

RELEASED
2012-03-03

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MD	DRAWING NO. D4434	REV. B
MFG. APPR.	EE	SHEET 3 OF 15	
APPROVED	MD	TITLE	SCALE
DE APPR.	#	COVER ASSEMBLY	NTS
DATE	12.02.22	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
2	1	D4434-3	BRACKET
3	1	D4434-5	BRACKET
4	1	D4441-1-060	RUBBER SEAL
5	6	MS20426AD4-4	RIVET



D4434-045 FWD OUTBOARD BRACKET ASSEMBLY

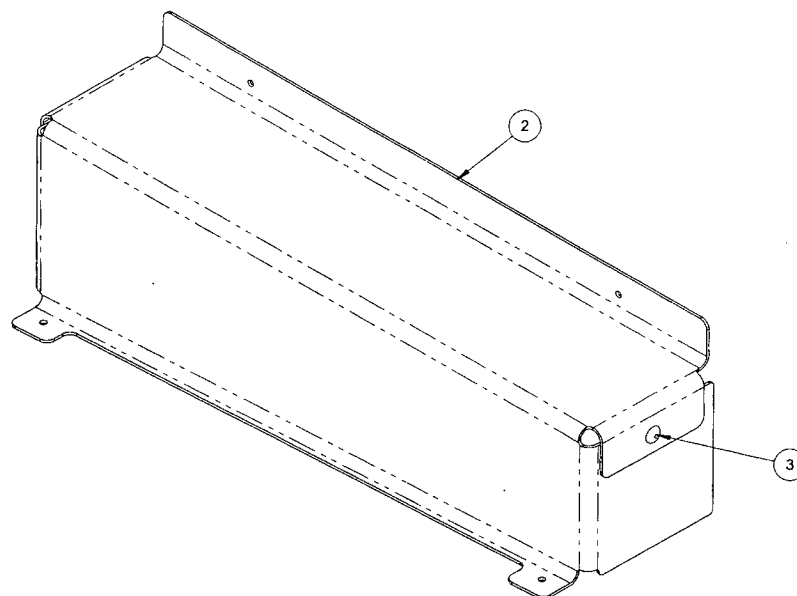
RELEASED
2012-03-02
MR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.365 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TRANSFER $\varnothing 0.129$ HOLE 6 PLACES AND CSK TO $\varnothing 0.225 \times 100^\circ$

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MR	DRAWING NO. D4434	REV. B
MFG. APPR.	EE		SHEET 4 OF 15
APPROVED	MR	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	MR		
DATE	12.02.22	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4434-047	COVER ASSEMBLY
2	1	D4434-7	BRACKET
3	2	MS20470AD4-3	RIVET



D4434-047 COVER ASSEMBLY

RELEASED
2012-03-02
NW

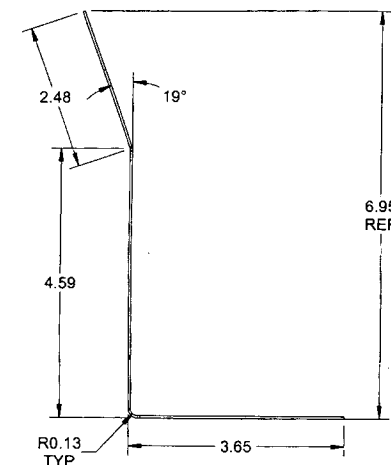
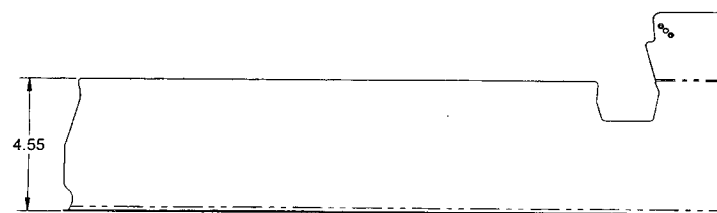
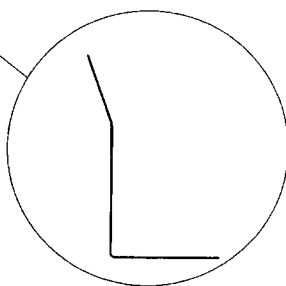
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.263 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	NW	DRAWING NO. D4434	REV. B
MFG. APPR.	JE		SHEET 5 OF 15
APPROVED	NW	TITLE	SCALE
DE APPR.		COVER ASSEMBLY	NTS
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83539

B
B2-6



D4434-1 BRACKET

DETAIL B C8-6
SCALE 2X

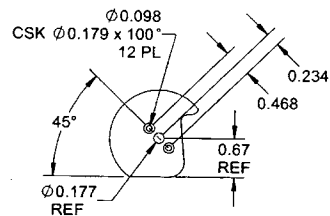
RELEASED
2012-03-02

NOTES:

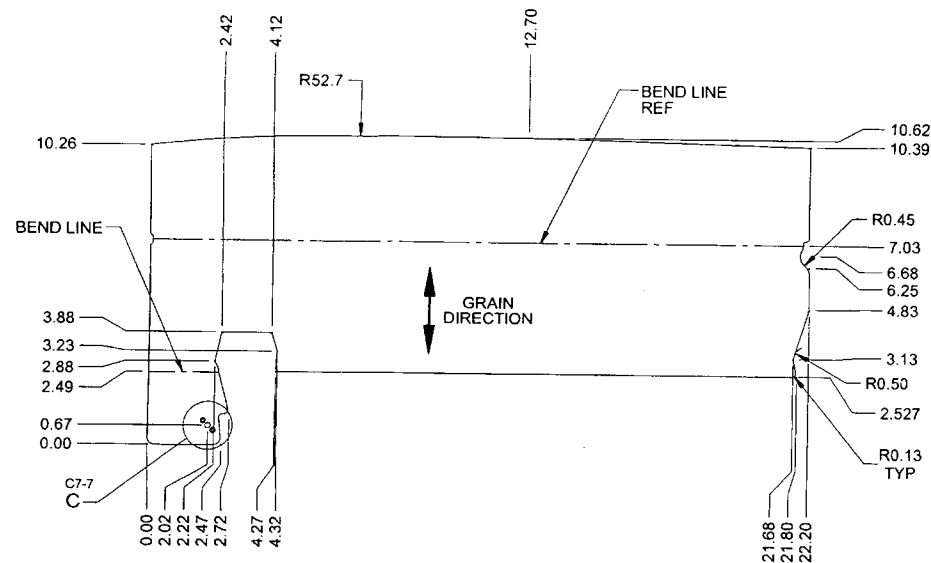
- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>W</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>E</i>		SHEET 6 OF 15
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	COVER ASSEMBLY	NTS
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DETAIL C
SCALE 2X



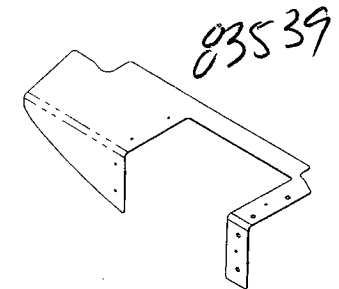
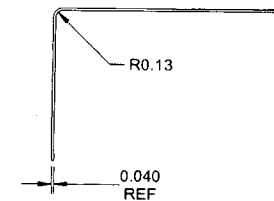
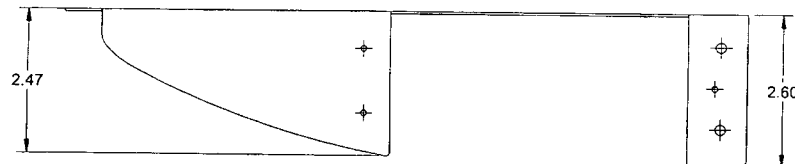
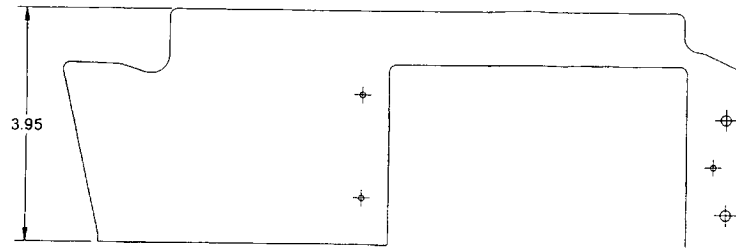
D4434-1F FLAT PATTERN

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4434	SHEET 7 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
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D4434-3 BRACKET

NOTES:

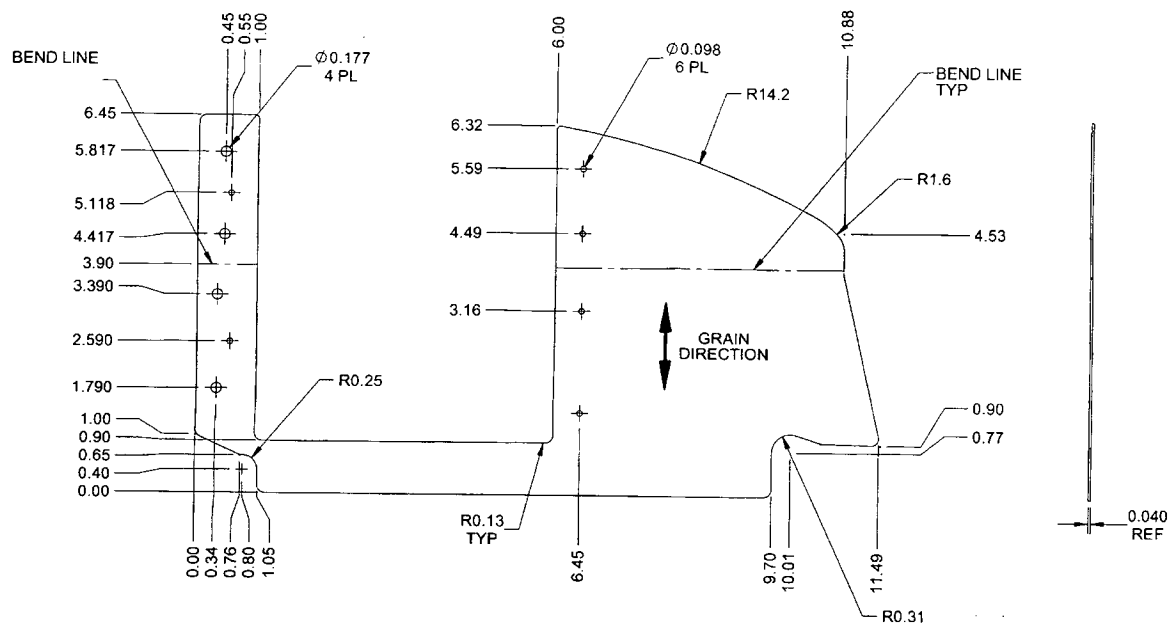
- 1) MATERIAL: MAKE FROM D4434-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 8 OF 15	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	
DATE	12.02.22	NTS	

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2012-03-02
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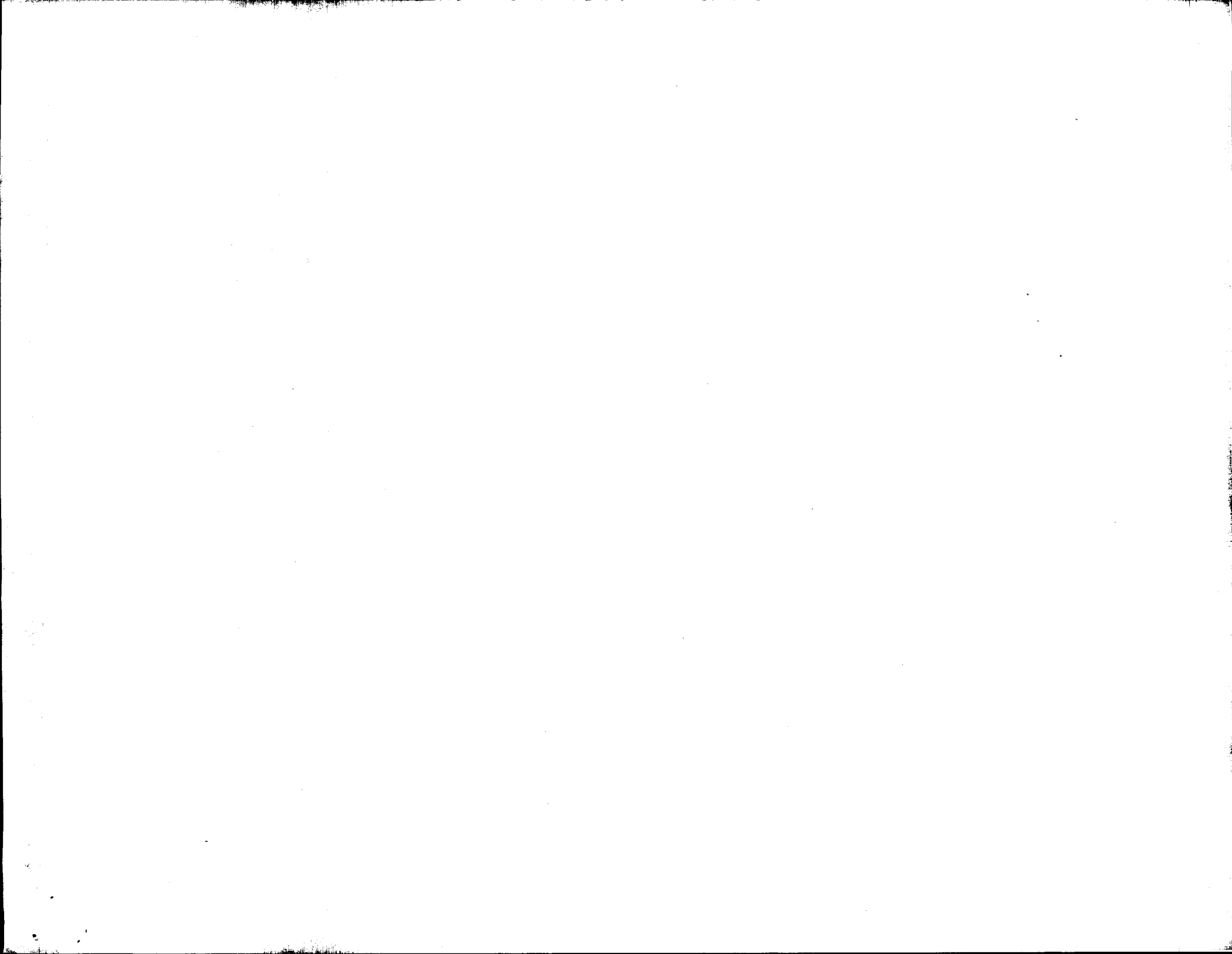
D4434-3F FLAT PATTERN

NOTES:

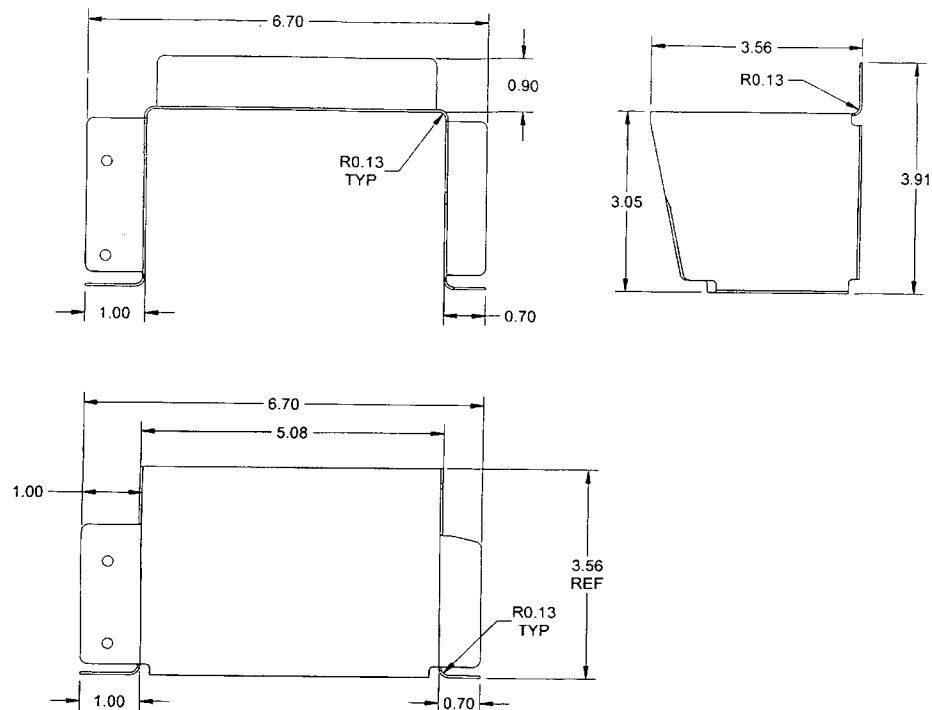
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 9 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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2012-03-02
[Signature]



835 39



D4434-5 BRACKET

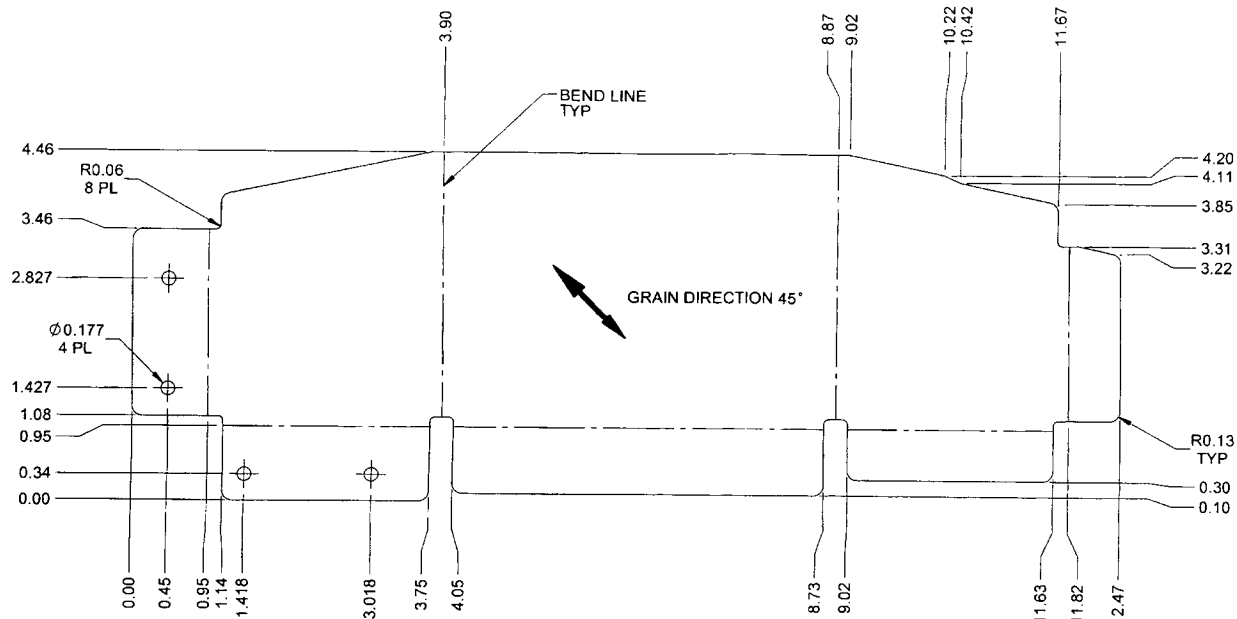
RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MAKE FROM D4434-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 10 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





83539



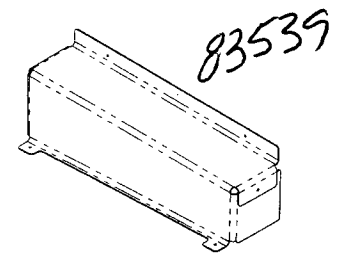
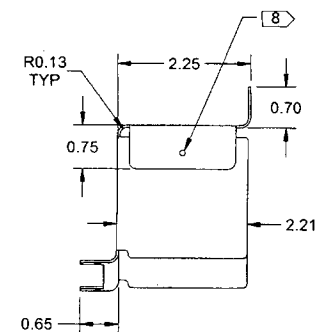
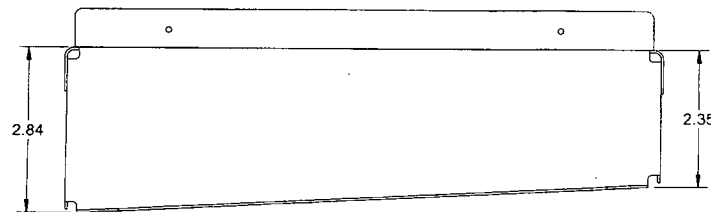
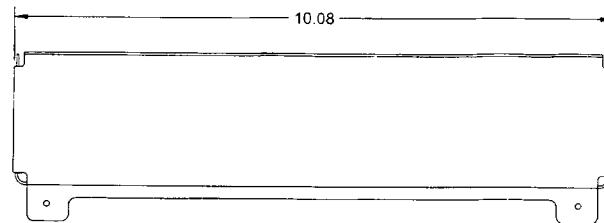
D4434-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4434	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		COVER ASSEMBLY	NTS
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2012-03-02



D4434-7 BRACKET

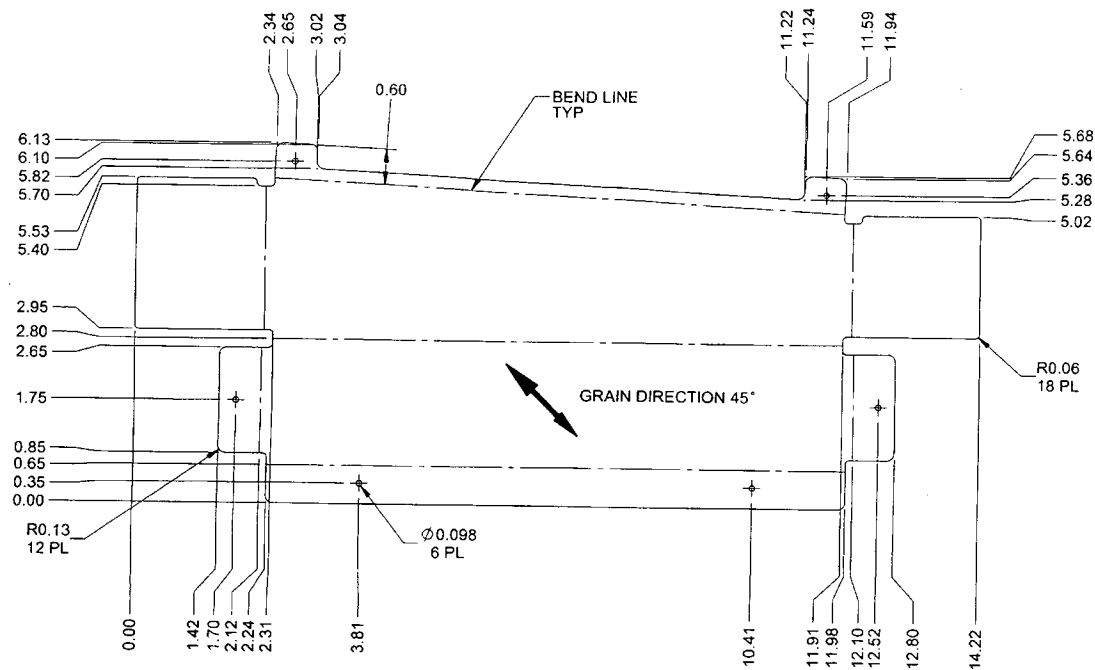
RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER Ø0.129 HOLE THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>EE</i>		SHEET 12 OF 15
APPROVED	<i>MP</i>	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	<i>MP</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	12.02.22		

83539



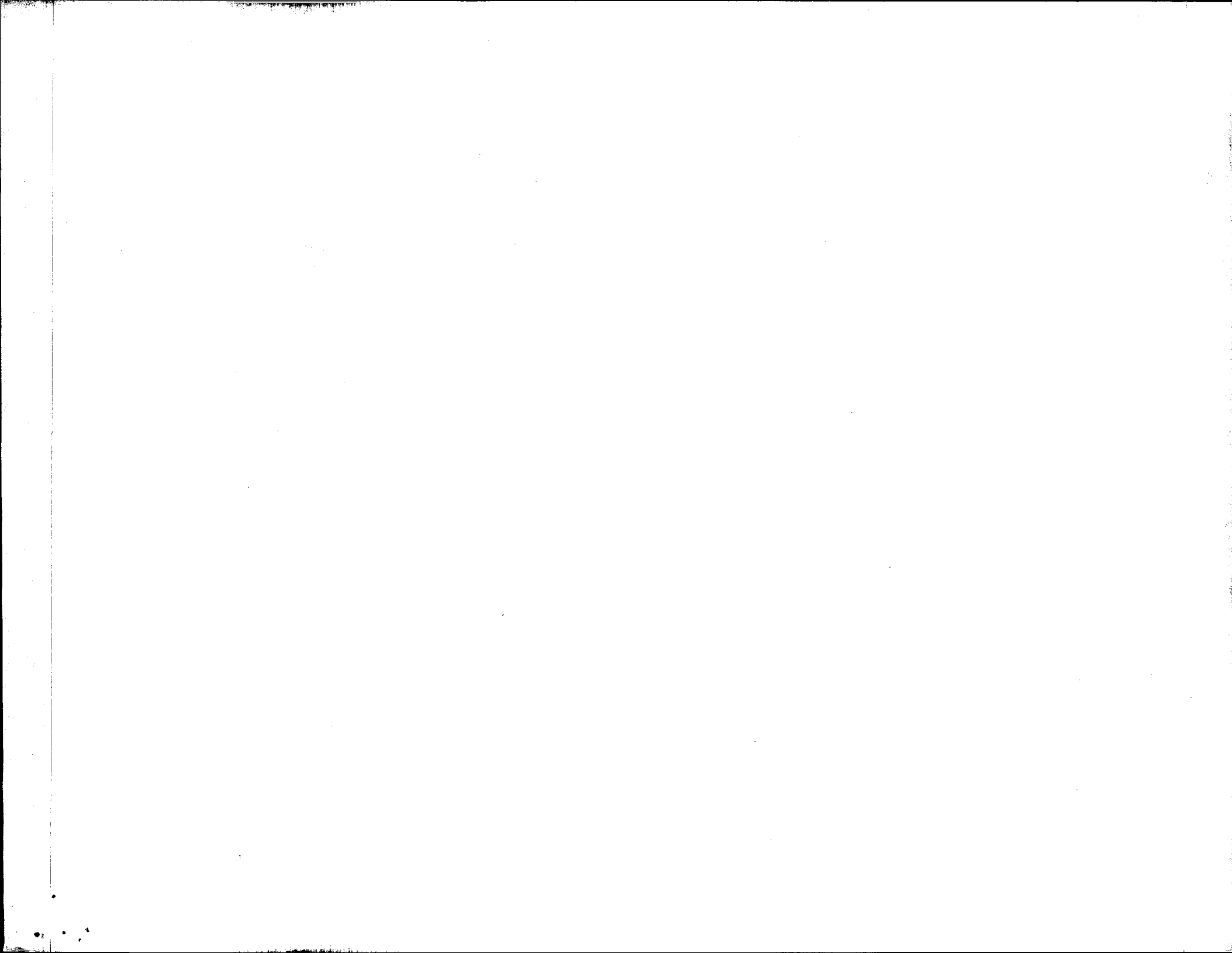
D4434-7F FLAT PATTERN

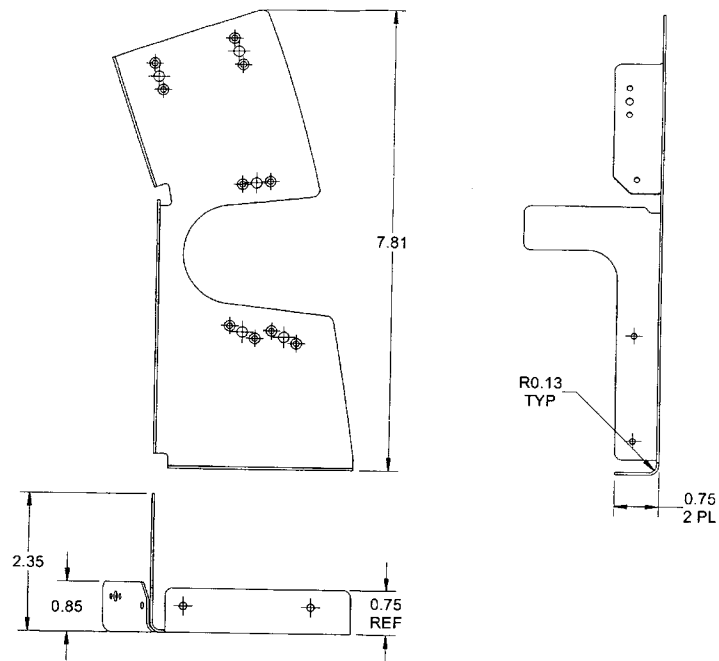
RELEASED
2012-03-03
JMP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4434	SHEET 13 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	COVER ASSEMBLY	NTS
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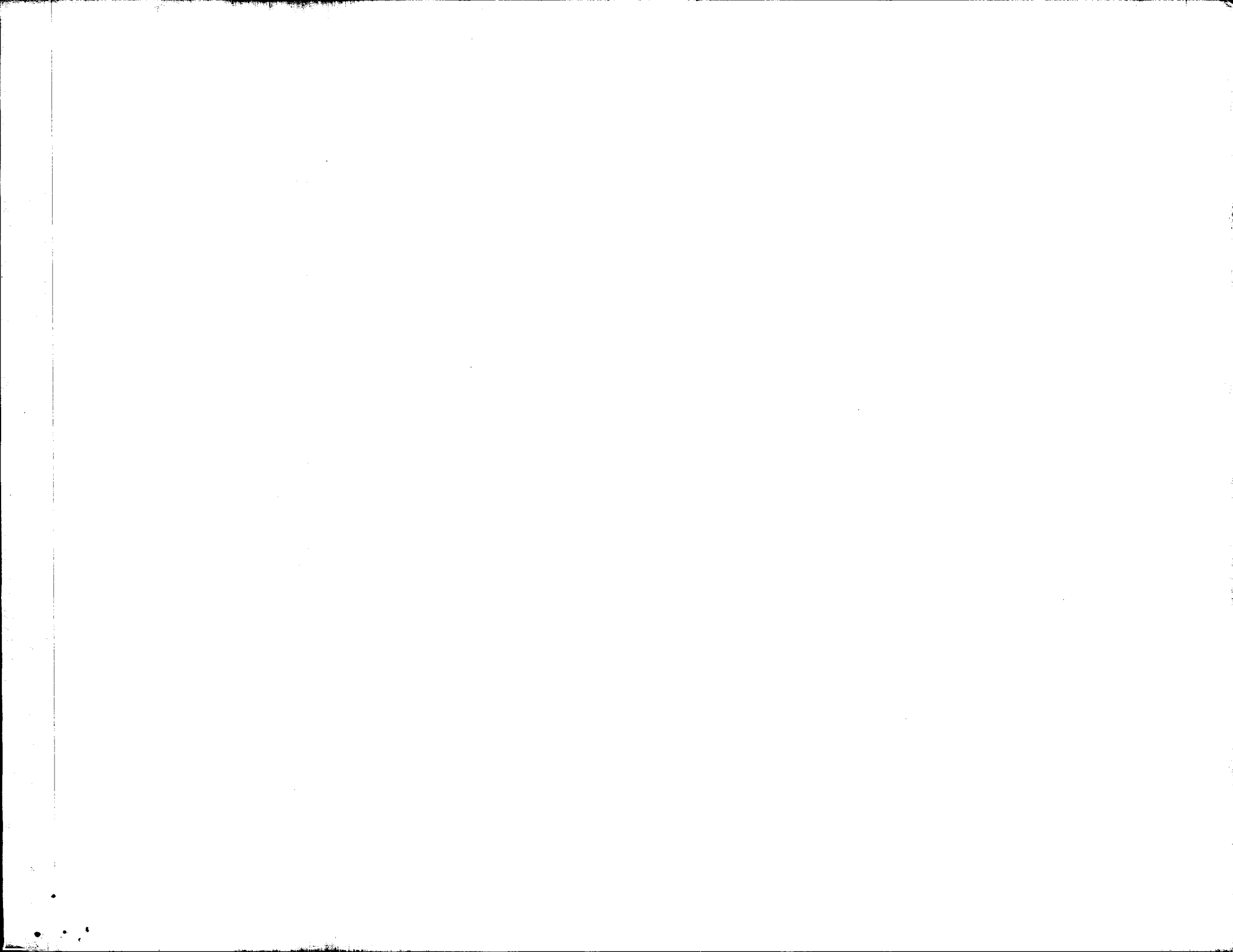
B D4434-9 BRACKET

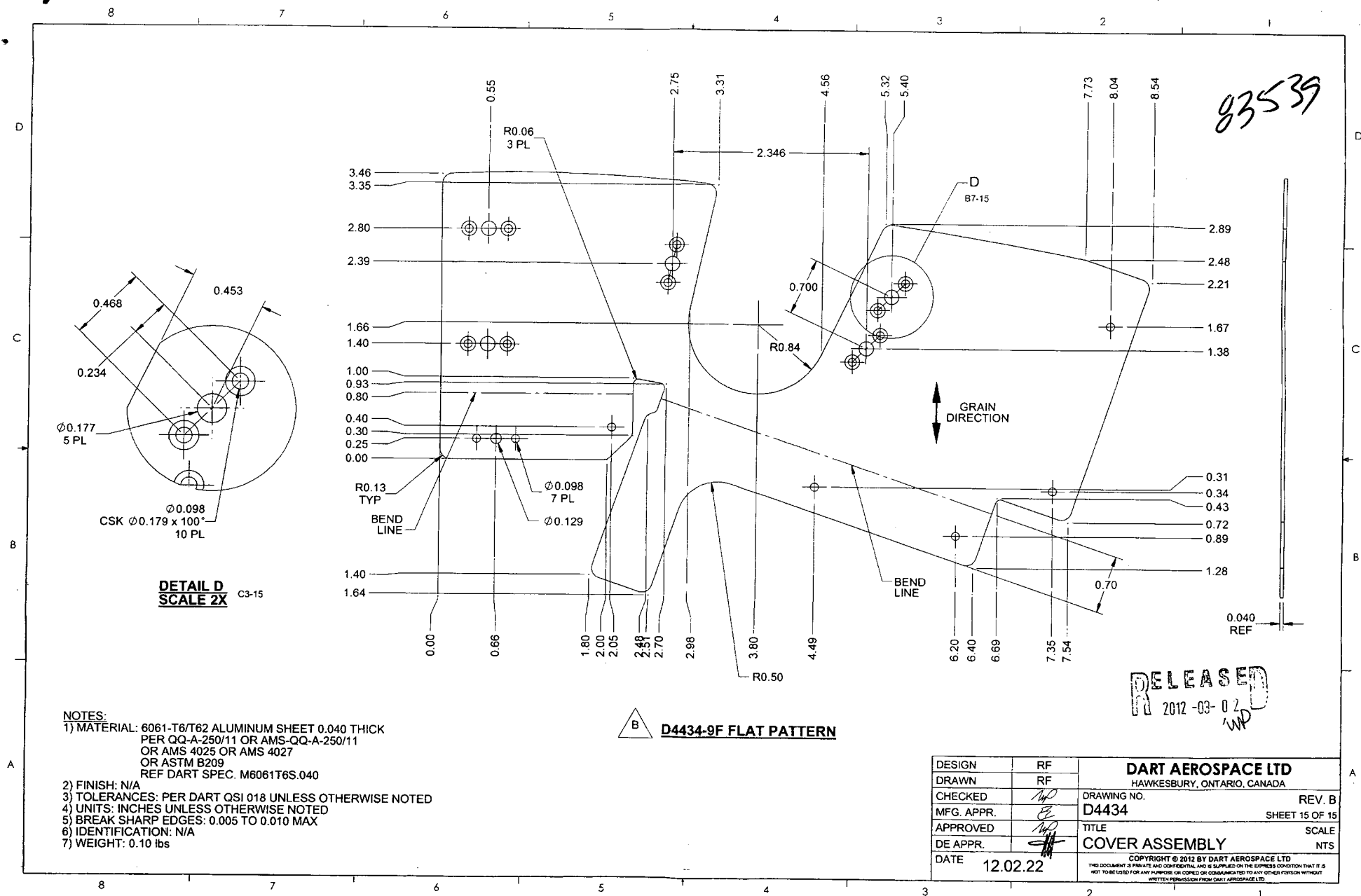
NOTES:

- 1) MATERIAL: MAKE FROM D4434-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>EE</i>		SHEET 14 OF 15
APPROVED	<i>MP</i>	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	<i>MP</i>	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.02.22		

RELEASED
2012-03-03
MP





DART AEROSPACE LTD		Work Order: 83539
Description: FWD INBOARD BRACKET ASSEMBLY		Part Number: D4434-1
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.098	2		V B62	
Ø .177	+ .005 - .001	.178	2		V	
.468	± .010	.470	2		V	
.234	± .010	.234	2		V	
.167	± .030	.171	2		V	
3.88	± .030	3.884	2		V	
10.26	± .030	10.281	2		T B/L	
2.527	± .010	2.533	2		V	
10.39	± .030	10.39	2		T	
2.02	± .030	2.019	2		V	
2.47	± .030	2.450	2		V	
2.72	± .030	2.714	2		V	
4.21	± .030	4.281	2		V	
22.20	± .030	22.20	2		T	
10.40	± .010	10.42	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-5-19	Date: 12/13/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1825

1-1825